

Work Order ID 61364

Thursday, August 19, 2010 1:57:18 PM



Page 1

Item ID: D3281-2L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd RH

Start Date: 8/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-8-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3281	DEO E-1								

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

DL #3 10/08/24

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240° F

Time IN: 5:00 pm

Time OUT: 7:00 am

*10/08/24 DL
10/08/25 DL*

DL 10/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Page 3

Item ID: D3281-2L08

Accept

Revision ID:

Item Name: Floor Protector, Fwd RH




Start Date: 8/19/2010 Start Qty: 3.00

Required Date: 8/25/2010 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							<u>Q. (x3) 10/08/25</u>
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>(x3)</u>
160  Packaging Packaging	Packaging Memo	0.00 0.00							<u>PP 61362</u> <u>10/8/31 SP 320</u>

Dart Aerospace Ltd

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Fwd RH

Start Date: 8/19/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31 *[Signature]*
C 2 10/8/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 19, 2010 1:57:17 PM

Page 1

Work Order ID: 61364



Parent Item: D3281-2L08



Parent Item Name: Floor Protector, Fwd RH

Start Date: 8/19/2010

Required Date: 8/25/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

IPP REV. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,563.470	5	15.78947			
Lexan Sheet													

Location

therm

Loc Qty

2563.47

2563.47

Loc Code

113427

15 sq ft. ok 10/08/25

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, Fwd RH		Part Number:	D3281-2
Inspection Dwg: D3281	Rev: DE <i>DL</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	<i>✓</i>			
Shape Definition	<i>✓</i>			
Texture Retention	<i>✓</i>			
Material imperfections such as bumps, cracks, voids, scratching	<i>✓</i>			

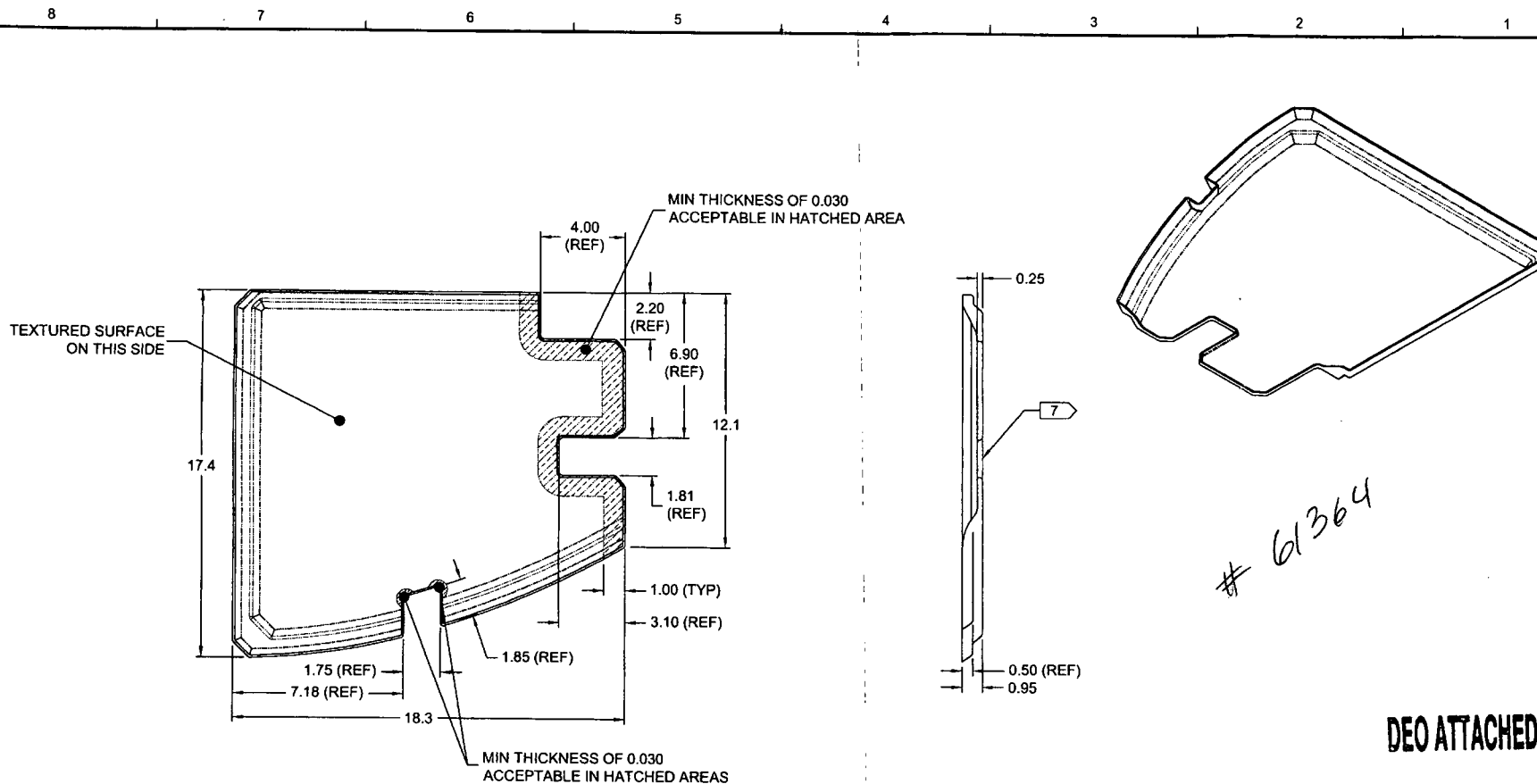
Measured by: <i>DL</i>	Date: <i>10/08/25</i>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	<i>18.3"</i>	<i>✓</i>			
17.4	+/-0.100	<i>17.375</i>	<i>✓</i>			
12.1	+/-0.100	<i>12.00</i>	<i>✓</i>			
0.95	+/-0.030	<i>0.977</i>	<i>✓</i>			
0.25	+/-0.030	<i>0.274</i>	<i>✓</i>			
0.030	Min	<i>0.046</i>	<i>✓</i>			
0.070	Min	<i>0.080</i>	<i>✓</i>			

Measured by: <i>DL</i>	Date: <i>10/08/25</i>
Audited by: <i>JB</i>	Date: <i>10/08/27</i>
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.07.23	Dwg Rev updated	KJ/DL	
D	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL <i>JA</i>	<i>DL</i>



D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

DEO ATTACHED

RELEASED

2010-02-03

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3281 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		FLOOR PROTECTOR NTS
DATE	10.01.05	COPYRIGHT © 2004 BY DART AEROSPACE LTD

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DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>K</i>	MFG. APPR. <i>JK</i>	APPROVED <i>JK</i>		DE APPR. <i>JK</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25		DATE 10.02.25		

PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

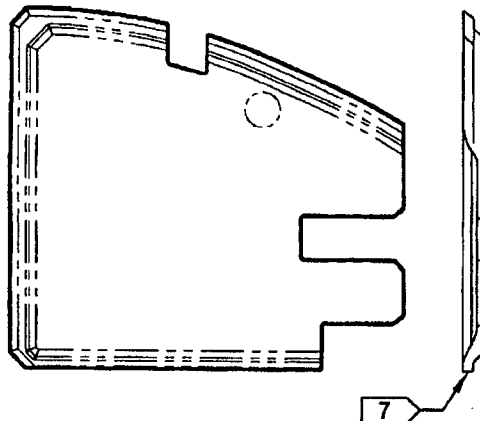
CHANGE

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

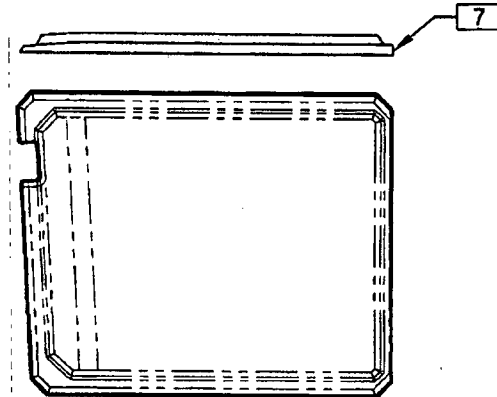
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb
D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



D3281-1L08 FLOOR PROTECTOR (SHOWN)
D3281-2L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING



D3281-3L08 FLOOR PROTECTOR (SHOWN)
D3281-4L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING

61364

RELEASED
2010-02-26
MD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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H:\FORMS\Quality Assurance\approved QA\NCRWO RevE